

Date: Thursday, 3/20/2008 9:54:08 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	02.750 SUPPORT		
Job Number	38123			Part Number	D28931		
Estimate Number	10829			Drawing Number	D2893 REV B		
P.O. Number				Project Number	N/A		
This Issue	3/20/2008	S.O. No.		Drawing Revision	B		
Prsh Rev.	NC	Type	MACHINED PARTS	Material			
First Issue	/ /			Due Date	4/3/2008	Qty:	9
Previous Run	37962			Um:	20	Each	
Written By	<u>108 03 20</u>						
Checked & Approved By							
Comment	<p>Est: C 02.11.26 Reformat; Added P/O KJ est D 06.04.19 removed alodine EC Est Rev:E Added priming as per Rev B 07-04-30 JLM est F 08.03.19 Re-format EC verified by: DD</p>						

Additional Product

Job Number:



Seq #:	Machine Or Operation:	Description :
1.0	DSK078	D2893-1 TURNING DETAIL

Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)
Machine: D2893-1 TURNING DETAIL
Batch: 38131

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS 1
Machine as per Folio FA081
Tumble & Deburr

J.L 08/04/21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 08/04/21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

84 08/04/21

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Mask Inside Bore for Priming

BL 08-04-22

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/20/2008 9:54:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 38123

Part Number: D28931

Job Number:



Seq. # Machine Or Operation:

Description :

6.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

ML 08 04 24

18

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RT 08-04-25 18

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ML 08 04 25

18

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/28 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38123
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.120							
L									
HAAS Section									
AA	2.985	3.005		3.003	2.994	2.992	2.991		
AB	0.440	0.460		.440	.440	.440	.440		
AC	0.125	0.160		.143	.145	.145	.146		
AD	0.040	0.060		.042	.042	.042	.041		
AE	0.188	0.193		.189	.189	.189	.189		
AF	0.125	0.160		.141	.143	.142	.144		
AG	0.140	0.160		.152	.152	.152	.150		
AH	1.360	1.400		1.380	1.368	1.371	1.371		
AI	0.040	0.060		.047	.048	.051	.052		
AJ	1.190	1.230		1.215	1.209	1.216	1.216		
AK	0.010	0.020		.011	.011	.011	.011		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.538	2.538	2.538	2.538		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by:	J.L.	Audited by:	8P
Date:	08/04/20	Date:	08/04/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	JL

DART AEROSPACE LTD	Work Order:	38123
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		2.992	2.993	2.992	2.992		
AB	0.440	0.460		.440	.440	.440	.440		
AC	0.125	0.160		.148	.145	.146	.146		
AD	0.040	0.060		.042	.043	.042	.042		
AE	0.188	0.193		.189	.189	.189	.189		
AF	0.125	0.160		.144	.144	.145	.143		
AG	0.140	0.160		.150	.149	.149	.149		
AH	1.360	1.400		1.368	1.368	1.371	1.373		
AI	0.040	0.060		.049	.051	.047	.049		
AJ	1.190	1.230		1.211	1.214	1.212	1.216		
AK	0.010	0.020		.011	.011	.011	.011		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.538	2.538	2.538	2.538		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by:	J.L.	Audited by:	8.F
Date:	08/04/21	Date:	08/04/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08.	Dimension AP revised	KJ/JLM	JL

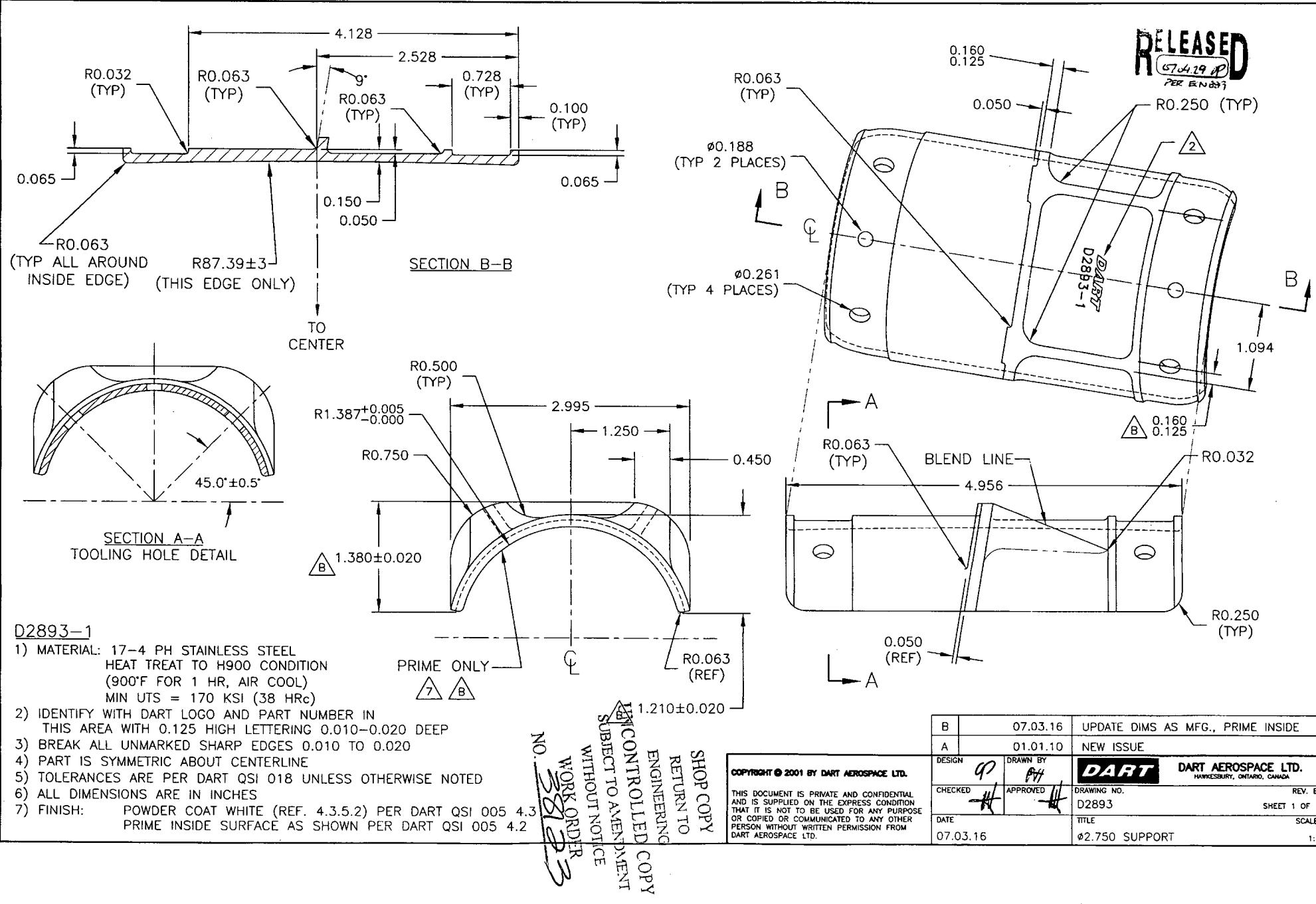
DART AEROSPACE LTD	Work Order:	38123
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		2.991					
AB	0.440	0.460		.440					
AC	0.125	0.160		.145					
AD	0.040	0.060		.042					
AE	0.188	0.193		.189					
AF	0.125	0.160		.144					
AG	0.140	0.160		.149					
AH	1.360	1.400		1.367					
AI	0.040	0.060		.052					
AJ	1.190	1.230		1.215					
AK	0.010	0.020		.011					
AL	0.053	0.073		.063					
AM	0.240	0.260		.250					
AN	2.518	2.538		2.538					
AO	84.39	90.39		87.39					
AP	0.261	0.266		.261					
AQ	0.053	0.073		.063					
AR									
AS									
Accept/Reject									

Measured by:	3.L	Audited by:	8/04/08
Date:	08/04/08	Date:	08/04/08

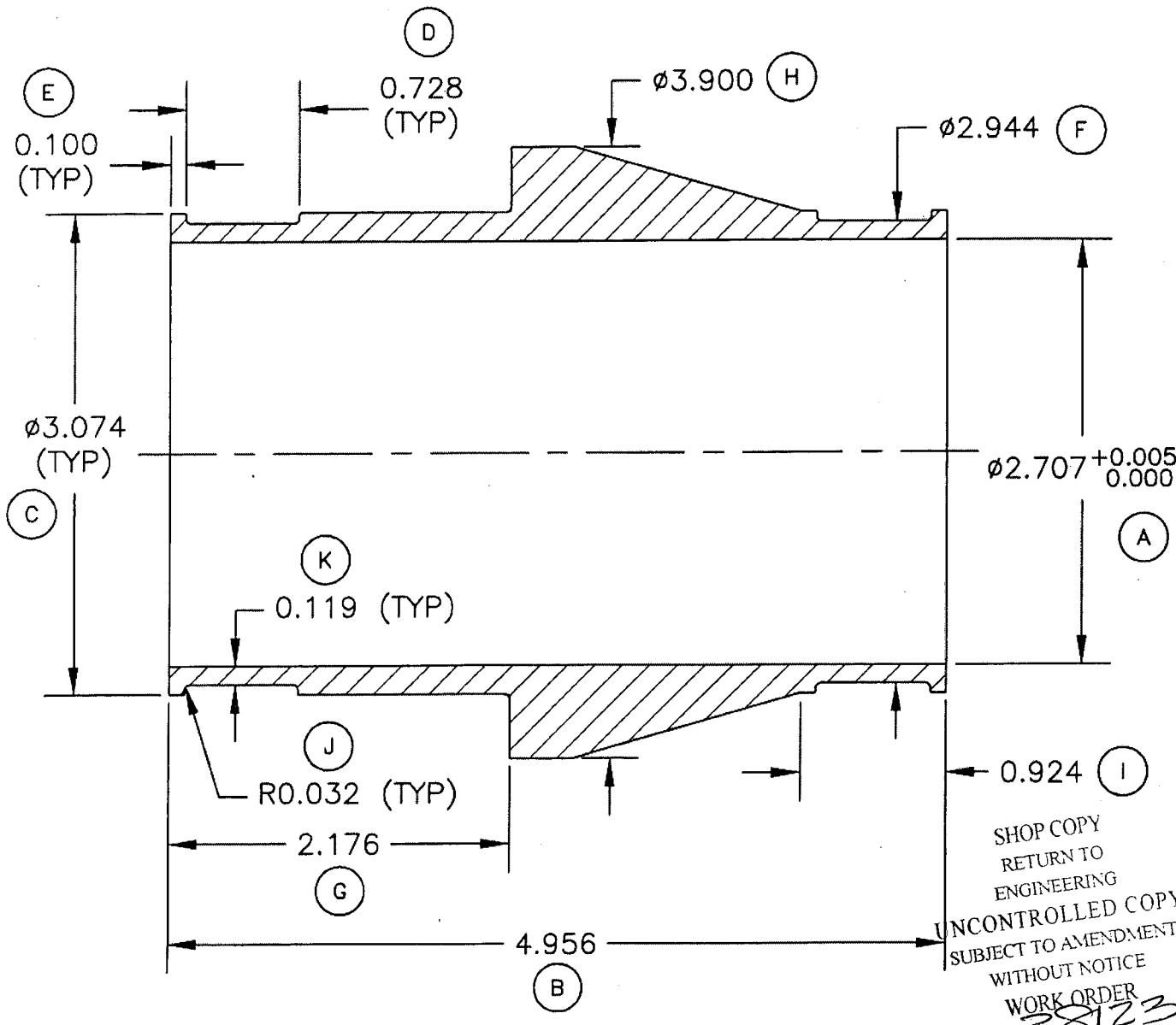
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	SJL





DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
[Signature] 03.07.01



D2893-1 TURNING DETAIL

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